Tuesday, 12/5/2006 8:15:29 AM

User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 29776 : 10175 **Estimate Number**

P.O. Number This Issue

: MA

: 12/5/2006

: 29620

: NHA-

S.O. No. : 1

: MACHINED PARTS Type

Part Number

Drawing Revision

Drawing Name

Drawing Number

Project Number

: N/A

: D2570

D2570 REV A

Material **Due Date**

: NIM : 12/23/2006

: BUSHING

Qty:

500 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est E 02.08

Re-format; Removed finishing; Material change K

J

Additional Product

Job Number:



Sea. #:

Machine Or Operation:

Description: 303 Round Bar .75"

HARDINGE CNC LATHE SMALL

M303R0750 1.0

Comment: Qty.:



0.0810 f(s)/Unit Total: 40.4775 f(s)

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

HARDINGE

2.0

3.0

4.0

5.0

Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA198

Deburr and tumble

INSPECT PARTS AS THEY COME OFF MACHINE

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

OB OG/12/15 510

D. f 06/12/11

501

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE By		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

				<u>ـــــــــــــــــــــــــــــــــــ</u>		<u> </u>	1 1			

Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date: 86/12/15
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date:

Tuesday, 12/5/2006 8:15:29 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29776

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER (CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-						
Part No	•	PAR #· Fault Category:	NCP: Ves	No DO	Δ.	Date:	

Part No:	<u> </u>	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	1
				QA: N/C Closed:	Date:	: .

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Approval Chief Eng	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C						
								:				
						,		•				

	.											

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29776
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	802	V			
0.060	+/-0.005	,061				
R0.010	+0.010/-0.000	,012				
Ø0.425	+0.000/-0.002	,424	V			
Ø0.257	+0.005/-0.000	. 259	/		_	
Ø0.750	+/-0.010	1745				
0.030 x 20°	+/-0.010	.030				

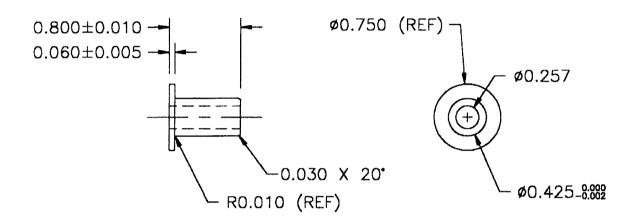
Measured by:	Audited by:	me	Prototype Approval:	N/A
Date: 06/12/10	Date:	06/12/10	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	74



DESIGN	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,			
CHECKTO	APPROVED	DRAWING NO.		REV.	
A	N	D2570	SHEET	1 OF	1
DATÉ	,	TITLE		SCA	Œ
96:09:16		BUSHING		1	1:1

RELEASED



BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 - 0.75 DIA STOCK

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE